

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	BEARPAW KIT (19"X16")	
Job Number	:	30377				
Estimate Number	:	12664				
P.O. Number	:	N/A	Part Number	:	D206559011	
This Issue	:	1/23/2007	Drawing Number	:	D2435 REV E1	
Prsht Rev.	:	NC	Project Number	:	N/A	
First Issue	:	N/A	Drawing Revision	:	E1	
Previous Run	:	N/A	Material	:	N/A	
Written By	:		Due Date	:	2/12/2007	Qty: <u>5</u> Um: Each
Checked & Approved By	:	<u>07.01.23</u>				
Comment	:	Est Rev:C 04.02.17 Blank size changed KJ/JLM				
	:	Est Rev:D 07-01-02 Was K10007 JLM				

Job Number:



1.0 DC DOCUMENT CONTROL



chg 005 07.01.24 KS.

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 4.5491 sf(s)/Unit Total: 45.4913 sf(s)
blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3
Material: Black UHMW 1"
(MUHMWB10)
Batch: M 103428

J.F. 07/02/10

⑤

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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3-Deburr

J.F. 07/02/10

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30377

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/02/10

(5)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.02.12

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1.6660 f(s)/Unit Total: 16.6600 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050

Rubber Cushion

B28042

9x5"

B30397

11x5"

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274

Radius Block

B28713

2 D2435(ref only)

Bearpaw

B30377

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438

Clamp

B28732

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/23/2007 7:31:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30377

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529

Washer

128733 ✓

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

1103444 ✓

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Batch:

1101124 ✓

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

1101938 ✓

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

119185 ✓

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S

Clamp

1103338 ✓

1 Paperwork package

304/02/125

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/02/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/23/2007 7:31:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30377

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 7/02/13 (5)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206559-011

Location: *Draft*

PC 7/02/13 (5)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



(G)

Comment: FINAL INSPECTION/W/O RELEASE

PC 7/02/13

Job Completion



U 07-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 30377
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.065 x 45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	0.197	✓			
D	R0.250	+/-0.030	0.250	✓			
E	0.250	+/-0.010	0.257	✓			
F	0.625	+/-0.030	0.630	✓			
G	0.25 x 45°	+/-0.030	0.255 x 45°	✓			
H	0.375	+/-0.010	0.377	✓			
I	19.000	+/-0.030	19.00	✓			
J	0.950	+0.030/-0.010	0.955	✓			
K	Ø0.260	+0.005/-0.000	0.261	✓			
L	Ø0.930	+/-0.030	0.931	✓			
M	0.30	+0.030/-0.000	0.320	✓			
N	0.375	+/-0.030	0.375	✓			
O	7.375	+/-0.030	7.376	✓			
P	4.250	+/-0.010	4.251	✓			
Q	2.000	+/-0.030	2.020	✓			
R	9.000	+/-0.010	9.001	✓			
S	15.750	+/-0.030	15.750	✓			

SAME AS
w/o D30337
J.F.
07/02/10

Measured by: J.L./J.F.	Audited by: MS	Prototype Approval:	N/A
Date: 07/02/08	Date: 07/02/09	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	J.F.

DART



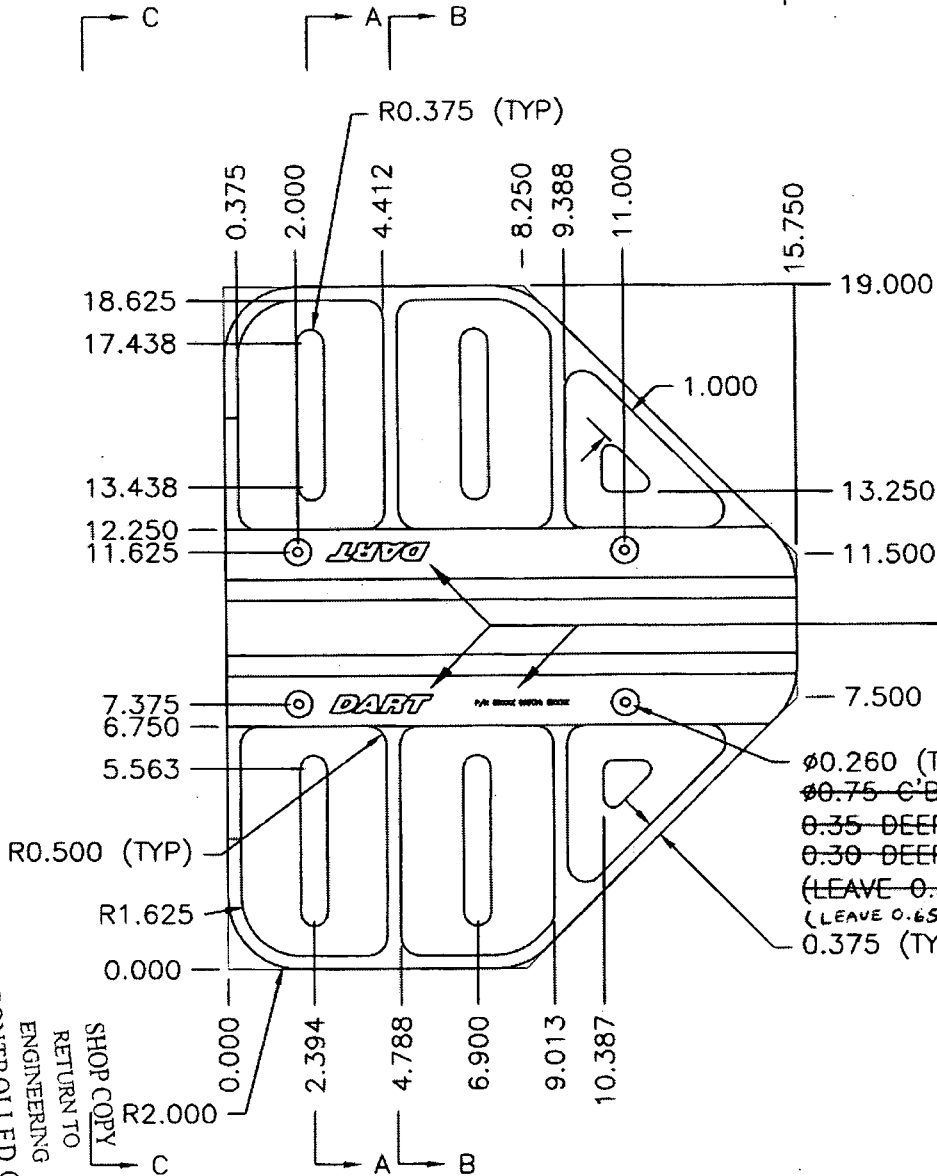
DESIGN	DRAWN BY	DRAWING NO.	REV. E
KE	KE	D2435	SHEET 1 OF 2
CHECKED	APPROVED	TITLE	SCALE
98.05.19	98.05.19	BEARPAW	1:5

RELEASED
98.06.17 KE

A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

EFFECTIVE	DEOS
9143	

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



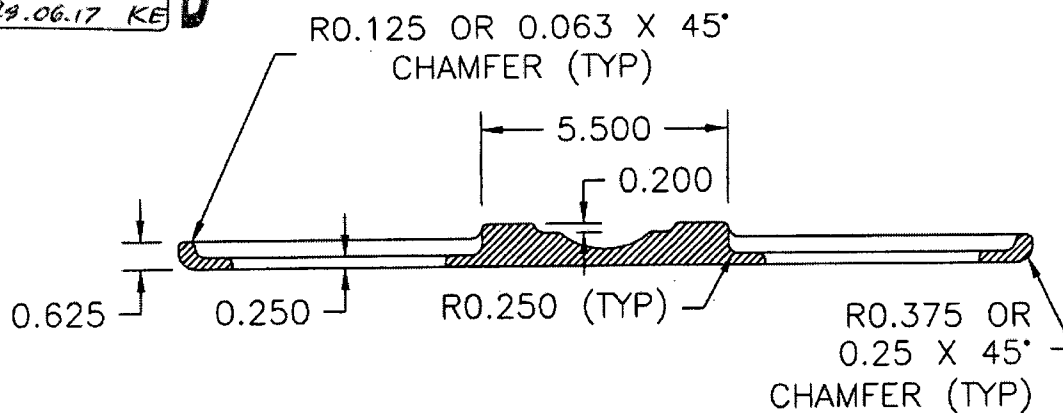
Copyright 1996 by DART Aerospace Ltd

UNCONTROLLED COPY
SUBJECT TO AGREEMENT
WITHOUT NOTICE
WORK ORDER
NO. 30371

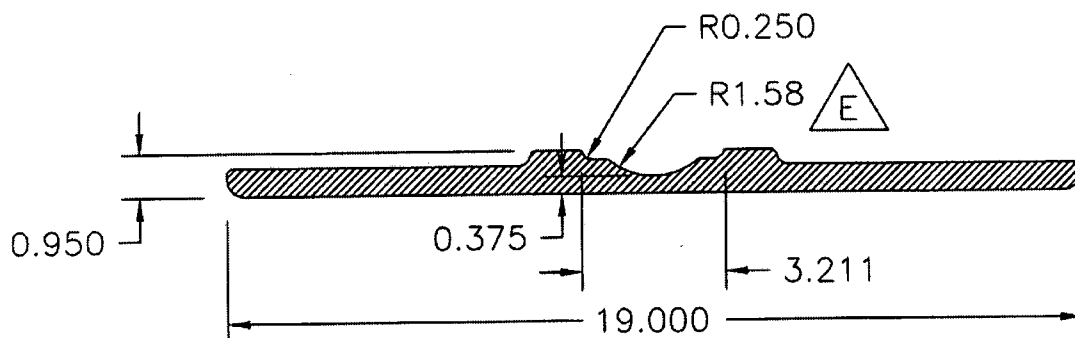


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DJE	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

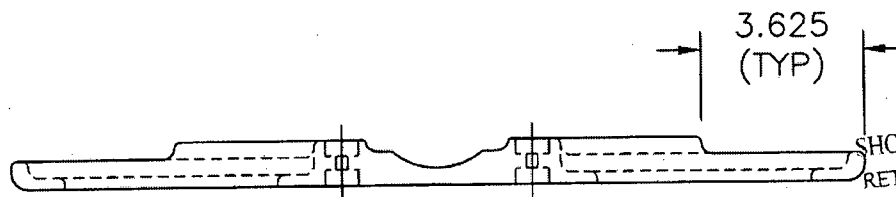
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30377

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-559

Job Number : 36674

Estimate Number : 10804

P.O. Number : N/A

This Issue : 09/01/2008

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Type : MACHINED PARTS

Previous Run : 00015

Part Number : Z_CUSTOM

Drawing Number : ECN1101

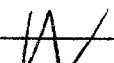
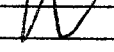
Project Number : N/A

Drawing Revision : N/A

Material : N/A

Due Date : 16/01/2008

Qty: 1 Um: Each

Written By : 
Checked & Approved By : 
Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REMOVE FROM STOCK:

D206-559-011

B34284 (10x) B30377 (x2) B30800 (x1) B32977 (x5)

D206-559-013

B32768 (9x) B30340 (2x)

D206-559-021

B28342 (x4)

D206-559-023

B25291 (x3) B34856 (x5)

D206-559-025

B28731 (x4)

ADD NEW PAPERWORK JCAB STC: STC-90-TYO
PER ECN 1101

RETURN TO STK

8/1/10 SD (45x) AS

2.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/01/11

Job Completion



U 28-06-11